

Date: Monday, 6/5/2006 7:47:10 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: GUIDE		
Job Number	: 27365					
Estimate Number	: 10367					
P.O. Number	: N/A			Part Number	: D31121	
This Issue	: 6/5/2006			S.O. No.	: D3112 REV B	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A			Drawing Revision	: B	
Previous Run	: 24674			Material	: N/A	
Written By	: <i>Shay Comment Below</i>			Due Date	: 6/30/2006	
Checked & Approved By	: <i>KA 06-06-05</i>			Qty:	6	
Comment	: Est. A 02.05.22 New Issue NG			Um:	Each	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0625X01500	6061-T6 Bar .625" x 1.5"	
		Comment: Qty.: 0.2385 f(s)/Unit Total : 1.4307 f(s) 6061-T6 Bar .625 X 1.500" Material: 6061-T6/T6511/T651 (QQ-A-225/8 OR QQ-A-200/8) Bar ref DART spec M6061T6B Batch <i>M17037</i>	<i>ML 06/06/01</i> 6
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blanks: 0.625" x 1.500 bar x 2.625" long.	<i>ML 06/06/11</i> 6
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA233 Note: Engrave / scribe DART P/N on part as per dwg. Deburr break all unmarked sharp edges .005 to 0.010	<i>ML 06/06/11</i> 6
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>ML 06/06/12</i> 6
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<i>SD 06/06/13</i> x6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

No

DQA:

Date: 06/06/21

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

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Process Sheet

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Drawing Name: GUIDE

Job Number: 27365

Part Number: D31121

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06.06.17

(3)

JP

7.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

DC ocal/19

(5)

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: 57408

26/6/20 (5)

10.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

26/6/20 (5)

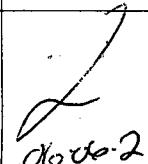
Job Completion



26/6/20 (5)

406-06-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06.06.17	6	Lost one in sewer when aboline		Lost and Not Found	SAB 06.06.17		06.06.17 	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	27365
Description: Guide	Part Number:	D3112-1
Inspection Dwg: D3112	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

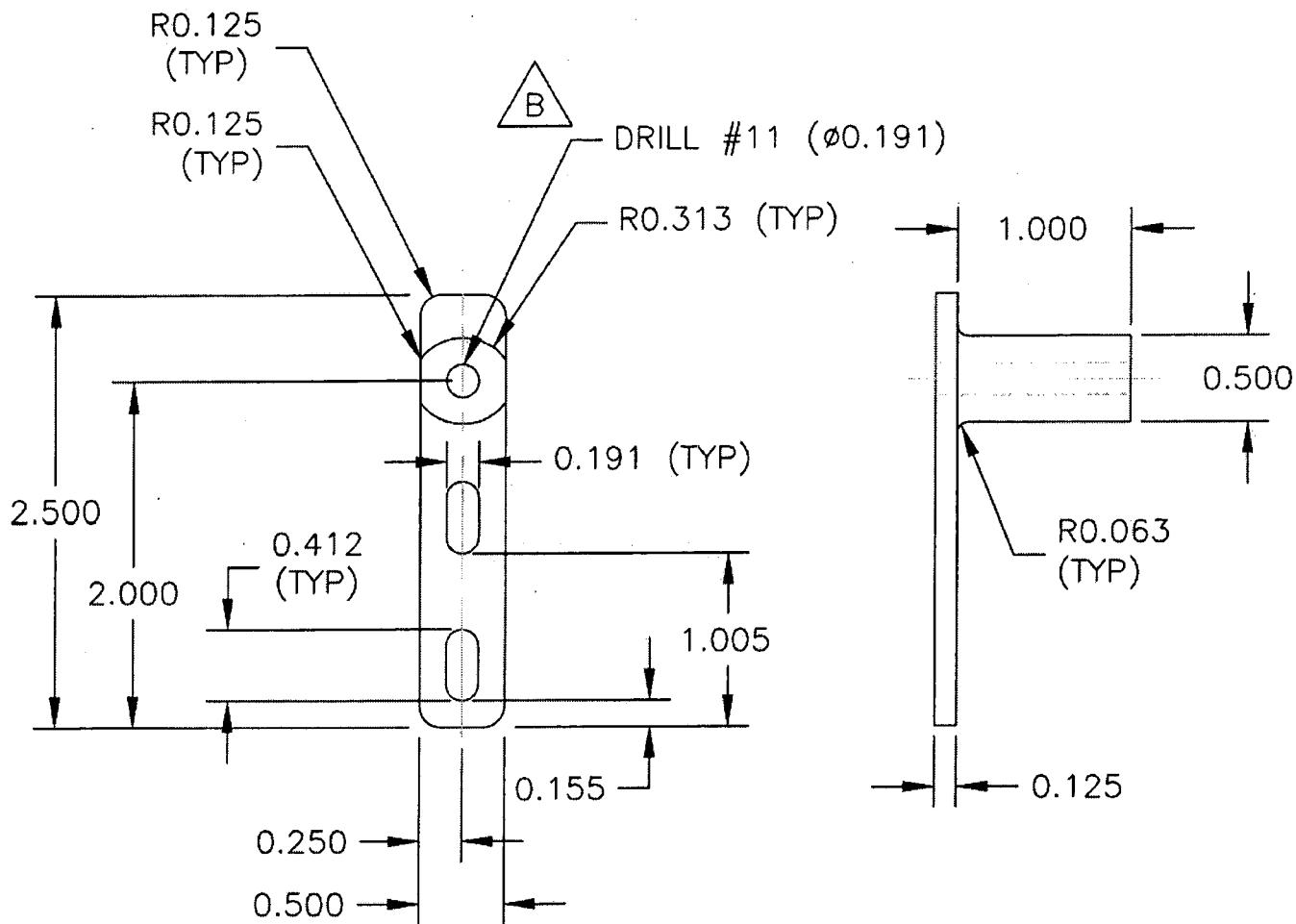
X First Article Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	06/06/12	Date:	06/06/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.07.07	New Issue	KJ/JLM	✓

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3112 REV. B SHEET 1 OF 1
DATE		TITLE GUIDE
04.10.18		SCALE 1:1
A	02.04.12	NEW ISSUE
B	04.10.18	ADD PART MARKING; Ø0.191 WAS Ø0.185

RELEASED
04.11.23**D3112-1 GUIDE****NOTES:**

- 1) MATERIAL: 6061-T6/T6511/T651 (QQ-A-225/8 OR QQ-A-200/8) BAR (REF. DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) POSSIBLE SUPPLIER: PREMIER P/N B30-23000-17
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27365

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